

Work Order ID 141013

Thursday, February 25, 2016 2:34:14 PM

141013

Page 1

Item ID: D066-1001-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: R66 Bearpaws with Wearplates - Large

Start Date: 1/14/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/26/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: *ML5*Date **FEB 25 2016**

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

IIN-D066-1001

REV B

DAS
6
9-89

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPPD066-1001-013

CHG 003

*ML5 1609226*DAS
28
9-89

APR 19 2016

4X

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

4X

DAS
27
9-89

FEB 25 2016

DAS
6
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

4X

DAS
28
9-89

APR 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition																																																													
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D066-1001-013

Location: _____

PPP Rev: _____

f013

4
DAS
28
9-89

APR 19 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.01

Quality Control

MLJ APR 19 2016

2m 16/04/19

MLJ APR 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause			FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	Past Due ☐							

Picklist Print

Thursday, February 25, 2016 2:34:19 PM

Page 1

Work Order ID: 141013

141013

Parent Item: D066-1001-013

D066-1001-013

Parent Item Name: R66 Bearpaws with Wearplates - Large

Start Date: 1/14/2016

Required Date: 1/26/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 13-10-30 JLM VERIFIED BY:DD IPP
REV:B 13.12.03 AS PER IIN REV.B DD VERF:JLM IPP REV:C
15.04.08 AS PER CHG003 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3456-1		Manufactured	No				Each	143.0000	4	16			
---------	--	--------------	----	--	--	--	------	----------	---	----	--	--	--

4 *D3456-1*
Washer

DAS
27
6-6 9-89
9
SW

Location	Loc Qty	Loc Code
FG	7	
25701	7	
ST038	86	
136922	11	
140756	75	
ST038A	50	
141125	50	

DAS
28
9-89

D3556-1		Manufactured	No				Each	0.0000	4	16			
---------	--	--------------	----	--	--	--	------	--------	---	----	--	--	--

4 *D3556-1*
Clamp

**

139070

DAS DAS
27 27
6-6 9-89
MAR 08 2016

D3601-1		Manufactured	No				Each	0.0000	8	32			
---------	--	--------------	----	--	--	--	------	--------	---	----	--	--	--

4 *D3601-1*
Radius Block

**

141269

DAS DAS
6 27
6-6 9-89
MAR 02 2016

D4930-3		Manufactured	No				Each	1.0000	2	8			
---------	--	--------------	----	--	--	--	------	--------	---	---	--	--	--

4 *D4930-3*
Bearpaw

**

140181

DAS DAS
6 27
6-6 9-89

Location	Loc Qty	Loc Code
ST462A	1	
112356	1	

DAS
28
9-89

FEB 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____									

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Work Order ID: 141013

141013

Parent Item: D066-1001-013

D066-1001-013

Parent Item Name: R66 Bearpaws with Wearplates - Large

Start Date: 1/14/2016

Required Date: 1/26/2016

Start Qty: 4.00

Required Qty: 4.00

D4952-041

Manufactured No

Each

22.0000

4 16

**

4 *D4952-041*

Wearplate Assembly

DAS
28
9-89

Location

Loc Qty

Loc Code

ST188

22

110051

4

114155

18

Each

4.0000

**

D4953-1

Manufactured No

4 *D4953-1*

Cushion

DAS
28
9-89

Location

Loc Qty

Loc Code

ST545

4

131442

4

Each

219.0000

**

AN4-12A

Purchased No

4 *AN4-12A*

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

10

120423

10

over003

100

m133990

100

ST344

109

m131957

9

m131180

100

DAS
6 27
9-89-89

DAS
27
9-89

DAS
27
9-89

DAS
6
9-89

FEB 25 2016

Thursday, February 25, 2016 2:34:19 PM

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Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐							
		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Work Order ID: 141013

141013

Parent Item: D066-1001-013

D066-1001-013

Parent Item Name: R66 Bearpaws with Wearplates - Large

Start Date: 1/14/2016

Required Date: 1/26/2016

Start Qty: 4.00

Required Qty: 4.00

AN4-15A

Purchased

No

Each

215.0000

4 16

AN4-15A

Bolt

**

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

40

120449

40

over003

100

m134055

100

ST343

75

m133284

3

m133769

72

AN4-16A

Purchased

No

Each

243.0000

4 16

AN4-16A

Bolt

**

Location

Loc Qty

Loc Code

FG

5

121541

5

ST343

238

M134055

38

M134134

200

DAS
28
9-89

DAS
6
9-89

FEB 25 2016

Thursday, February 25, 2016 2:34:19 PM

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Page 3

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Parent Item Name: R66 Bearpaws with Wearplates - Large

141013

D066-1001-013

Start Date: 1/14/2016

Required Date: 1/26/2016

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0463J

Purchased

No

Each

4.821.000

8

32

**

DAS
6 27
9-89

NAS1149D0463.I

WASHER

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

237

M129390

41

M132035

196

ST263

3236

M134039

3236

ST269

1348

M130799

360

M132317

100

M132677

888

MS21042L4

Purchased

No

Each

2,298.000

12

48

**

134039

MS21042I 4

Locknut

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

41

m133363

41

GA

456

m133769

456

ST007

1500

m134055

1500

ST303

204

m133769

204

ST305

97

m130922

97

DAS
6 27
9-89

FEB 25 2016

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Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

REF. only

DART AEROSPACE LTD.

DAS
28
9-8c

IIN-D066-1001
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4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D066-1001-011	8.3 lb	0.0 in	0.0 in-lb	123.89 in	1028 in-lb
Bearpaw Installation (Small)	3.74 kg	0.0 m	0.0 m-kg	3.14 m	11.7 m-kg
D066-1001-013	9.8 lb	0.0 in	0.0 in-lb	124.98 in	1225 in-lb
Bearpaw Installation (Large)	4.41 kg	0.0 m	0.0 m-kg	3.17 m	14.0 m-kg

5.0 PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		D066-1001-011	BEARPAW INSTALLATION (SMALL)
	X	D066-1001-013	BEARPAW INSTALLATION (LARGE)
4	4	D3456-1	Washer
4	4	D3556-1	Clamp
8	8	D3601-1	Radius Block
2		D4930-1	Bearpaw
	2	D4930-3	Bearpaw
4	4	D4952-041	Wearplate
4	4	D4953-1	Cushion
4	4	AN4-12A	Bolt
4	4	AN4-15A	Bolt
4	4	AN4-16A	Bolt
8	8	NAS1149D0463J	Washer
12	12	MS21042L4	Nut (or MS21042-4)

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Revision: B
Date: 13.11.13